



006876

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

8536
see 1

RBT18419-9
Job Sheet 185157



Part No: RBT18419-9

Job Qty: 4 ea

Part Name: Mooring Adapter Assembly Female)



5134826

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBT18419 Rev.A IPP Rev. A 18.06.07 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/30/18	0.00	0.00	Start Up Small Fab-2		MLL
110	Small Fab	4 pcs		11/30/18	0.00	4.00	Small Fab-3		MLL
120	QC	4 pcs		11/30/18	0.00	0.00	QC5		SB 18/12/05
130	Packaging	4 pcs		11/30/18	0.00	0.00	Packaging3-1		MLL
140	QC21-SA	4 Ea		11/30/18	0.00	0.00	QC21		DAS DEC 05 2018

Part Op
Descriptions: 110 - 1-Assemble as per DWG. See note 8 & 9.

21
9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
NAS1756-12	Remove Before Flight	4 Ea (1 ea)	90-Start up Operation	5134216
3555T51	Shackle 1/2", 4400 Lbs	4 Ea (1 ea)	110-Small Fab	5122135
3896T31	Ferule 1/16 X 3/8" - Aluminum	8 Ea (2 ea)	110-Small Fab	5084066
CL-2-C	Lanyard Wire	2.6640 ft (.666 ea)	110-Small Fab	5093863
RBT18419-5	Mooring Adapter (Female)	4 Ea (1 ea)	110-Small Fab	5091430

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	NAS1756-12	4	376	0
110-Small Fab	3555T51	4	6	0
	3896T31	8	702	0
	CL-2-C	3	557	0
	RBT18419-5	4	4	0



Container No: S134826



Part: RBT18419-9

Job No: 185157

Serial No/Batch: S134826

Revision: A

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

ns

be found.

Plex 10/23/18 11:11 AM Dart.lajeunesse.marie

Date: 12/05/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

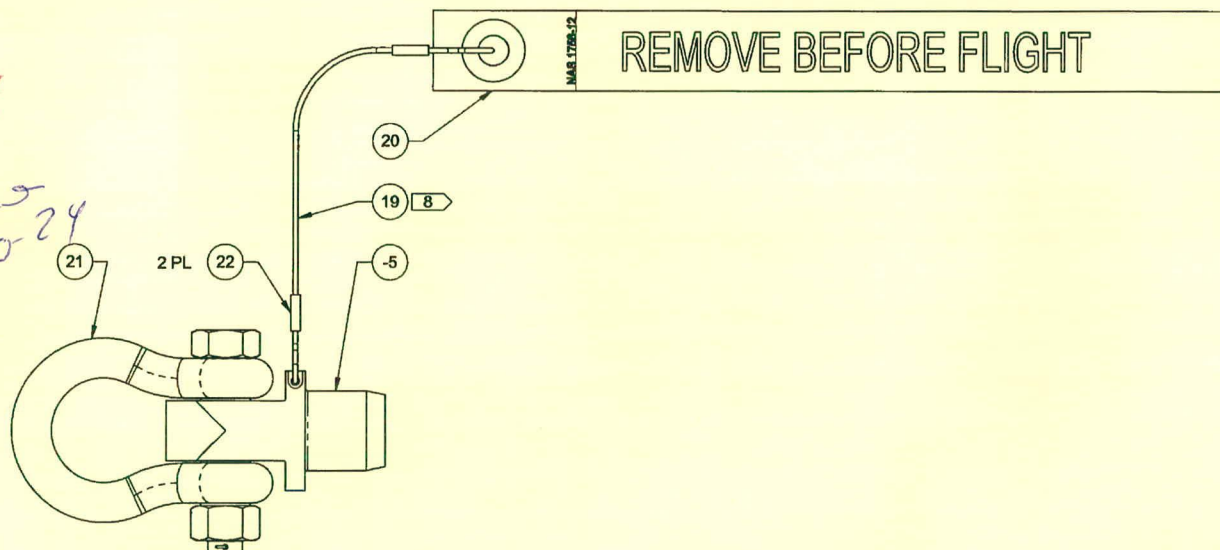
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

ITEM #	QTY	PART #	PART TITLE
-5	1	RBT18419-5	MOORING ADAPTER (FEMALE)
19	1	CARR-LANE#CL-2-C	NYLON COATED LANYARD
20	1	NAS 1756-12	REMOVE BEFORE FLIGHT
21	1	McMaster#3555T51	SAFETY PIN SHACKLE
22	2	McMaster#3896T31	1/16" X 3/8" WIRE ROPE COMPRESSION SLEEVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185157 MLG
18-10-24



NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) LANYARD LENGTH IS 6.0" +/- 1.0" ONCE CRIMPED
- 9) ASSEMBLE AS SHOWN, INSTALL SHACKLE NUT HAND TIGHT, THEN FOLD OVER COTTER PIN

RBT18419-9 MOORING ADAPTER ASSY (FEMALE)

DESIGN	KT	DART AEROSPACE LTD	
DRAWN	KT 03/02/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML 03/08/2018	TOOL PART #	REV. A
MFG. APPR.	DP 03/08/2018	RBT18419	SHEET 4 OF 8
APPROVED	ML 03/08/2018	TITLE	SCALE
DATE 6/4/2018		AIRCRAFT MOORING ADAPTER KIT	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

